

Date: Tuesday, 19/08/2008 4:05:56 PM
 User: Julie Lecocq

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE KIT	
Job Number	: 41472			Part Number	: K10003	
Estimate Number	: 10532			Drawing Number	: K10003	
P.O. Number	:			Project Number	: N/A	
This Issue	: 19/08/2008	S.O. No.	:	Drawing Revision	: D	
Prsh Rev.	: NC			Material	:	
First Issue	: //	Type	: MACHINED PARTS	Due Date	: 15/09/2008	
Previous Run	: 40194			Qty:		
Written By	:			Um:	Each	
Checked & Approved By	: JLD 08-8-20					
Comment	: Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL JLD 08.9.12
		Comment: DOCUMENT CONTROL Create White labels only per PPP K10003 CHG 006 8/9/15
2.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit
3.0	D2570	Bushing
		Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s) Bushing S+9 Qty. Part Number Description Batch 24 D2570 Bushing 841638 X 25 40986 X 107 40197 X 108
4.0	D2571	Saddle, Fwd Out 205
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, Out S+2 Qty. Part Number Description Batch 1 D2571 Saddle 39806 X 2 B40514 X 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41472				Part Number: K10003
Job Number:				
Seq. #:		Machine Or Operation:		Description :
5.0	D2572	Saddle, Fwd In 205		
<i>HHT</i>				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)				
Saddle, Fwd, In				
Pick:				
Qty	Part Number	Description	Batch	
1	D2572	Saddle	B40515	<i>AS 08/09/15 X8</i>
6.0	D2573	Saddle, Aft Out 205		
<i>HHT</i>				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)				
Saddle, Aft, Out				
Pick:				
Qty	Part Number	Description	Batch	
1	D2573	Saddle	B40518 X3 B39808 X5	<i>AS 08/09/15 X8</i>
7.0	D2574	Saddle, Aft In 205		
<i>HHT</i>				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)				
Saddle, Aft, In				
Pick:				
Qty	Part Number	Description	Batch	
1	D2574	Saddle	40517	<i>AS 08/09/15 X8</i>
8.0	D27361	Lug Assembly, 205 GHW		
<i>HHT</i>				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)				
Lug Assembly				
Pick:				
Qty	Part Number	Description	Batch	
1	D2736-1	Bracket	39841	<i>AS 08/09/15 X8</i>
9.0	D27363	Lug Assembly, 205 GHW		
<i>HHT</i>				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)				
Lug Assembly				
Pick:				
Qty	Part Number	Description	Batch	
1	D2736-3	Bracket	39842 X6	<i>AS 08/09/15 X8</i>
<i>B39223X2</i>				

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT

Job Number: 41472

Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D2747	Set Screw
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XXX+X



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	39224



AS 08/09/15 (X8)

11.0	D2876	Saddle Spacer
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XXX+X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B3e275



AS 08/09/15 (X8)

12.0	D2877	Saddle Spacer
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XXX+X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	36276

All Same batch



AS 08/09/12 (X8)

13.0	D35331	Set Screw
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XXX+X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Set Screw

Batch:

B28093 X10 B41606 X10



AS 08/09/12 (X8)

14.0	AN46A	Bolt
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XXX+X



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	M107534



AS 08/09/12 (X8)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41472			Part Number: K10003
Job Number:			
<hr/>			
Seq. #:	Machine Or Operation:	Description :	
15.0	AN446A	Bolt	
<i>HTT X</i>			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)			
Bolt			
Pick:			
Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M168246
<i>S (X)</i>			<i>AS 08/09/12 (X)</i>
16.0	AN451A	Bolt	
<i>HTT X</i>			
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)			
Bolt			
Pick:			
Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M168376
<i>S (X)</i>			<i>AS 08/09/12 (X)</i>
17.0	AN612A	Bolt	
<i>HTT X</i>			
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)			
Bolt			
Pick:			
Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M167823
<i>S (X)</i>			<i>AS 08/09/12 (X)</i>
18.0	AN960JD416	Washer	
<i>HTT X</i>			
Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)			
Washer			
Pick:			
Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M168161
<i>S (X)</i>			<i>AS 08/09/12 (X)</i>
19.0	AN960JD616	Washer	
<i>HTT X</i>			
Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)			
Washer			
Pick:			
Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M168521
<i>S (X)</i>			<i>AS 08/09/12 (X)</i>

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

01/06/08

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 41472

Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :	
20.0	MS21042L4	Nut	
		Comment: Qty.: 28.0000 Each(s)/Unit Total : 224.0000 Each(s) Nut Pick: 88 Qty Part Number Description Batch 29 MS21042L4 Nut (or MS21042-4) M167499	AS 08/09/12 (X)
21.0	D3407045	Tow Ring	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Tow Ring batch: 40404	AS 08/09/12 (X)
22.0	D34561	Washer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Washer batch: 145 B46285	AS 08/09/12 (X)
23.0	MS210434	Nut	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Nut batch: M168672	AS 08/09/12 (X)
24.0	D34175	Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer batch: 41060	AS 08/09/12 (X)
25.0	D38121	Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer batch: B41006	AS 08/09/12 (X)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
26.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: INSPECT KITS 100% FOR COMPLETENESS		<i>8/08/15 (6)</i>
27.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>I</u>		<i>8/08/15 (6)</i>
28.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>8/09/15 (A)</i>
Job Completion		<i>MF 08-09-15</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.07 *H*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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